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Mazdoor Kisan Shakti Sangathan

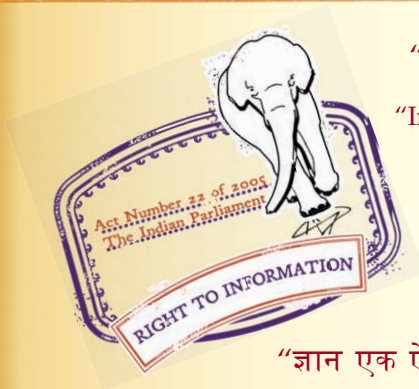
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“Step Out From the Old to the New”

IS 6672 (1989): Cotton Tapes for Berets, Mercerized [TXD
12: Narrow Fabrics, Webbing and Braids]



“ज्ञान से एक नये भारत का निर्माण”

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“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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Indian Standard
**COTTON TAPES FOR BERETS,
MERCERIZED — SPECIFICATION**
(First Revision)

भारतीय मानक
बेरेट के लिये सूती टेप, मर्सरीकृत — विशिष्ट
(पहला पुनरीक्षण)

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NEW DELHI 110002

FOREWORD

This Indian Standard (First Revision) was adopted by the Bureau of Indian Standards on 16 October 1989, after the draft finalized by the Narrow Fabrics, Webbing and Braids Sectional Committee had been approved by the Textile Division Council.

This standard which was first published in 1972 has been revised on the basis of experience gained during its use. Following are the major changes carried out in this revised version:

- a) Requirement of pH value has been modified,
- b) Sulphur dyes have been prohibited, and
- c) Sampling requirement and criteria for conformity have been modified keeping in view the practical difficulties.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (*revised*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

Indian Standard

COTTON TAPES FOR BERETS, MERCERIZED — SPECIFICATION

(First Revision)

1 SCOPE

1.1 This standard prescribes the constructional particulars and other requirements of braided cotton tapes used in the manufacture of berets.

2 REFERENCES

2.1 The Indian Standards listed at Annex A are necessary adjuncts to this standard.

3 MANUFACTURE

3.1 Yarn

The braided cotton tape shall be manufactured from mercerized cotton yarn of nominal count $15 \text{ tex} \times 2$ (or 40 s/2).

3.1.1 The barium activity number of the mercerized yarn shall be not less than 160 when determined as per IS 1689 : 1973.

3.2 Tape

The tape shall be manufactured on a 33 spindle braiding machine with two ends working as one. It shall be flat braided under even tension with uniform and firm selvages. The weave shall be as agreed to between the buyer and the manufacturer.

3.2.1 It shall be free from major braiding defects listed at Annex B.

3.2.2 It shall also be free from sizing, filling and dressing materials and substance liable to cause subsequent tendering.

3.3 Dyeing

When required, the tape shall be manufactured from dyed yarns. Sulphur dyes shall not be used.

4 REQUIREMENTS

4.1 Physical

The tape shall conform to the physical requirements specified in Table 1.

4.2 The tape shall also conform to the requirements specified in Table 2.

4.3 Sealed Sample

If in order to illustrate or specify properties of the tape not covered in the standard, a sample has been agreed and sealed, the supply shall be in conformity with sample in such respect.

4.3.1 The custody of the sealed sample shall be a matter of prior agreement between buyer and seller.

5 MARKING

5.1 Each roll of tape shall be marked with the following information:

- a) Name of the material;
- b) Manufacturer's name, initials or trademark, if any; and
- c) Year of manufacture.

5.1.1 The tape rolls may also be marked with the Standard Mark.

6 PACKING

6.1 Tapes shall be packed as per the requirement of the buyer.

7 SAMPLING AND CRITERIA FOR CONFORMITY

7.1 Sampling

Unless otherwise agreed, the number of rolls to be selected at random shall be as given in Table 3.

Table 1 Physical Requirements of Mercerized Cotton Tapes for Berets
(Clause 4.1)

	Length	Width	Mass	Number of Threads	Breaking Load on 25 cm Between Grips
	(1) m 100 ± 1.5	(2) mm 10 ± 2	(3) g/100 m 220 ± 10	Min (4) Full width 66	Min (5) N 295
Methods of Test	IS 1954 : 1969	IS 1954 : 1969	IS 1964 : 1970	—	IS 1969 : 1985

Table 2 Chemical Requirements of Mercerized Cotton Tapes for Berets
(Clause 4.2)

SI No. (1)	Characteristics (2)	Requirements (3)	Methods of Test (4)
i)	Colour fastness:		
	a) Light	4 or better	IS 2454 : 1985
	b) Washing : Test 4	4 or better	IS 765 : 1979
	c) Organic solvents	4 or better	IS 688 : 1988
	d) Perspiration	4 or better	IS 971 : 1983
ii)	pH value	5.5 to 8.5	IS 1390 : 1983 (Cold Method)

Table 3 Sampling
(Clause 7.1)

No. of Rolls in the Lot (1)	Sample Size (2)	Permissible Number of Defective Rolls (3)	Sub-sample Size (4)
Up to 100	8	0	3
101 „ 300	13	1	4
301 „ 500	20	2	5
501 „ 1 000	32	3	7
1 001 and above	50	5	10

7.2 Criteria for Conformity

It shall be as follows:

Characteristic	Sample Size	Criteria for Conformity
Length, width, threads in full width	As per column 2 of Table 3	Defective rolls not to exceed the number given under column 3 of Table 3
Mass, breaking load, colour fastness and pH value	As per column 4 of Table 3	All the test specimens shall pass the requirements.

ANNEX A (Clause 2.1)

LIST OF REFERRED INDIAN STANDARDS

IS No.	Title	IS No.	Title
IS 688 : 1988	Method for determination of colour fastness of textile materials to organic solvents (<i>first revision</i>)		cotton textile materials (<i>first revision</i>)
IS 765 : 1979	Method for determination of colour fastness of textile material to washing: Test 4 (<i>second revision</i>)	IS 1954 : 1969	Methods for determination of length and width of fabrics (<i>first revision</i>)
IS 971 : 1983	Method for determination of colour fastness of textile materials to perspiration (<i>first revision</i>)	IS 1964 : 1970	Method for determination of weight per square metre and weight per linear metre of fabrics (<i>first revision</i>)
IS 1390 : 1983	Methods for determination of pH value of aqueous extracts of textile materials (<i>first revision</i>)	IS 1969 : 1985	Methods for determination of breaking load and elongation of woven textile fabrics (<i>second revision</i>)
IS 1689 : 1973	Method for determination of barium activity number of	IS 2454 : 1985	Methods for determination of colour fastness of textile materials to artificial light (xenon lamp) (<i>first revision</i>).

ANNEX B (Clause 3.2.1)

LIST OF MAJOR BRAIDING DEFECTS

- | | |
|---------------------------------------|---|
| a) Breaks in one or more sheath ends; | d) Frequent knots; |
| b) Badly made knots in yarn; | e) Tight or slack braiding; and |
| c) Loops in yarns; | f) Mechanical damage, cuts, frayed portion. |

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Amendments Issued Since Publication

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